

Work Order ID 160797

Thursday, May 04, 2017 10:38:27 AM

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Item ID: D350-567-111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Super-Sized Vertical Reference Floor Window
Start Date: 5/17/2017 Start Qty: 2.00 *?
Required Date: 5/26/2017 Req'd Qty: 2.00 *?
Reference: (P.A.)SCHEDULED/S DAS 21 9-89
Approvals: Process Plan: P.A. Date: 2017/05/04 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***
Cust Item ID:
Customer:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-567	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels and DT8439 Template per PPP D350-567-111 CHG007								
110	Packaging	0.00							
110	Packaging	0.00							
Packaging	Memo								
Packaging	Pick Packing Kit								
	ENSURE DT 8439 TEMPLATE IS INCLUDED								
120	QC4- 100% Inspect kits for completeness	0.00							
120	QC	0.06							
Quality Control	Memo								

DAS 6 JUN 27 2017

DAS 27 9-89
JUL 05 2017DAS 28 9-89
JUL 05 2017DAS 27 9-89
JUL 05 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective : WAG 7S 100				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
				6/4 23 DR-6																																																													
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Item ID: D350-567-111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Super-Sized Vertical Reference Floor Window
Start Date: 5/17/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/26/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging						DAS 27 9-89	DAS 28 9-89	
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-111 Location: FG032								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

JUL 05 2017

17/7/6 

 JUL 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

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Work Order ID: 160797

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Parent Item: D350-567-111

D350-567-111

Parent Item Name: Super-Sized Vertical Reference Floor Window

Start Date: 5/17/2017

Required Date: 5/26/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C Re-format 05-11-09 JLM
 IPP Rev:D Added DT8439 Template to Step 1 07-06-26 JLM
 IPP Rev:E CHG#3 ECN 1055 07-11-21 DD verified by:EC
 IPP Rev:F 08-10-07 as per revD DD verified by: IPP
 REV:G 13.10.15 AS PER IIN REV.E DD VERF:JLM IPP REV:D
 16.04.25 as per chg007 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-567-113		Manufactured	No			110	Each	1.0000	1	2			
D350-567-113									**				DAS 28 9-89
Replacement Exterior Super-sized Window													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG033		1							
				157196		1				160796			
D350-567-115		Manufactured	No			110	Each	0.0000	1	2			
D350-567-115									**				DAS 28 9-89
Replacement Interior Window										160795			

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JUL 05 2017

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Revision ID:						
Item Name:	Super-Sized Vertical Reference Floor Window				Stop	*NS2*
Start Date:	5/17/2017	Start Qty: 2.00	*2*	Cust Item ID:		
Required Date:	5/26/2017	Req'd Qty: 2.00	*2*	Customer:		
Reference:	(P.A.)SCHEDULED/S					
Approvals:	Process Plan: <i>RA</i>	Date: <i>2017/05/01</i>	Tooling:		Run	Start *NR1*
	QC:	Date:	SPC (Y/N):		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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IIN-D350-567	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels and DT8439 Template per PPP D350-567-111 CHG007								
110	Packaging	0.00							
110	Packaging								
Packaging	Memo	0.00							
Packaging	Pick Packing Kit								
	ENSURE DT 8439 TEMPLATE IS INCLUDED								
120	QC4- 100% Inspect kits for completeness	0.00							
120	QC								
Quality Control	Memo	0.06							

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JUN 28 2017



Transport
Canada

Transports
Canada

Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH92-18

Issue No.: 6

Approval Date: April 21, 1992

Issue Date: February 04, 2009

Responsible Office:

Ontario

Aircraft/Engine Type or Model:

EUROCOPTER FRANCE AS 350 BA, AS 350B, AS 350B1, AS 350B2, AS 350B3, AS 350D, AS 350D1, AS 355 E, AS 355 F, AS 355 F1, AS 355 F2, AS 355 N, AS 355 NP

Canadian Type Certificate or Equivalent:

EUROCOPTER FRANCE AS 350 BA, AS 350B, AS 350B1, AS 350B2, AS 350B3, AS 350B3, AS 350D, AS 350D1, H-83
EUROCOPTER FRANCE AS 355 E, AS 355 F, AS 355 F1, AS 355 F2, AS 355 N, AS 355 NP H-87

Description of Type Design Change:

Installation of vertical reference (floor) window.

Installation/Operating Data:

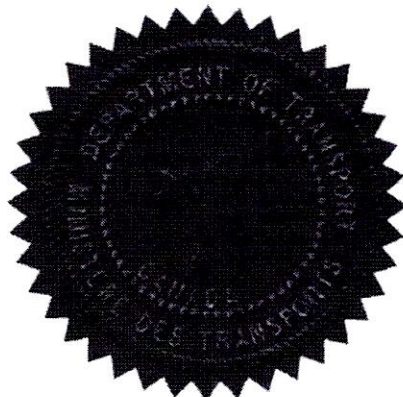
Required Equipment and Limitations:

Manufacturing must be accordance with Dart Aerospace Ltd. Master Drawing List MDL-D350-567, Revision A dated January 23, 2009 or later TC approved revision.

Installation must be in accordance with Dart Aerospace Installation Instructions D350-567, Revision D, dated July 8, 2008 or later TC approved revision.

Maintenance must be in accordance with Dart Aerospace Instructions for Continued Airworthiness, ICA-D350-567, Rev 0 dated January 20, 2009 or later TC accepted revision is required.

- END -



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.


M. Mariotti
For Minister of Transport

Canada